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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3913-041
Job Sheet 204918



Part No: D3913-041 **Job Qty:** 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 12/23/19 **Job Tracking No:**
Due Date: 1/10/20 **Created By:** Marie Lajeunesse
Type: Stock **Description:**

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	1/10/20		0.00	19.61	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		CPC
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	1/10/20		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		DAS
							QC 9 - 50		43
							QC 9 - 9		J-89
120	QC 5	1 pcs	1/10/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		DAS
							QC 5 - 49		43
							QC 5 - 51		9-89



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Container No: S245912



Part: D3913 - 041

Job No: 204918

Serial No/Batch: S245912

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
125 Handfinish - 2-1 Pressure- B4B	1 pcs	1/10/20	0.00	0.29		Handfinish - 2 - 1 - B4B	HL 20-1-4
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	
						Handfinish - 2 - 4 - B4B	
130 Powdercoat - 2 White Gl(S)- B4B	1 pcs	1/10/20	0.00	0.93		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BL 20-01-9.
						Powdercoat - 4 - B4B	
140 QC 3	1 pcs	1/10/20	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	HL 20-1-10
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
150 Handfinish - 4-1-Assembly- B4B	1 pcs	1/10/20	0.00	0.50		Handfinish - 4 - 1 - B4B	HL 20-1-16
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	

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160 QC 5	1 pcs	1/10/20	0.00 0.00	Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
170 Packaging 3-1 - Stock - B4B	1 pcs	1/10/20	0.00 0.00	QC 5 - 30	
				QC 5 - 40	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	

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				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
				Packaging 3 - 37 - B4B		
180 QC 21 - SA	1	1/10/20	0.00	0.00	QC 21 - SA - 21	21
	pcs				QC 21 - SA - 70	21
					QC 21 - SA - 53	

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Part Op 100 - Weld per dwg A/R S.S. rod Batch: 139015 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect
Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to
fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket 4- Weld D4672-1 blanking plates as per dwg
110 - QC9- Inspect visual per QSI004- Fusion Welds
120 - QC5- Inspect part completeness to step on W/O
125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder
coat
140 - QC3- Inspect Part Finish
150 - Assemble as per dwg - Pick Kit
160 - QC5- Inspect part completeness to step on W/O
170 - Identify as per dwg & Stock Location:
180 - QC21- Final Inspection - Work Order Release

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5214321
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5237664
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5211077
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5237362
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5242573
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5237153
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	5236847
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5242669
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	5231789
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5233314
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5231158
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5238413
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	5242694
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5240039
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5240031
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	5236536
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5236300
AN3-10A	BOLT	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5235320
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5196541
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5218152
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	5216387
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5241606
NAS1149FN832P	Washer (AN960-8)	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5136369

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	18	0
	D3913-1	1	9	0
	D3913-15	1	23	0
	D3913-3	1	9	0
	D3913-7	2	34	0
	D3913-9	1	8	0
	D3916-041	2	10	0
	D3916-5	3	17	0
	D4016-1	3	30	0
	D4017-7	3	30	0
	D4017-9	2	12	0
	D4020-11	2	12	0
	D4021-1	3	32	0
	D4034-041	1	9	0
	D4034-043	1	7	0
	D4672-1	2	23	0
	M304EX0.75-16F	32	1,199	0
	AN3-10A	6	219	0
	D2931	2	543	0
	D4021-5	2	57	0
150-Handfinish - 4-1-Assembly-B4B	MS20600-AD4W3	2	371	0
	MS21042L3	6	1,198	0
	NAS1149F0332P	12	4,702	0
	NAS1149FN832P	2	1,652	0
Part Specifications				
Specifications could not be found.				

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NCR No.

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐			DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐											
Date :	Sequence #:		QTY Affected :		MRB (QS1042)											
Description Work Order Deviation					Disposition											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐					FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐											
											Completed By					
											Lead hand / Supervisor					
											QC / QA Coordinator					